

Work Order ID 74154

Monday, September 26, 2011 10:31:57 AM



Page 1

Item ID: D3407-3

Accept



Setup Start



Revision ID:

Item Name: Stem

Stop



Start Date: 9/26/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100 0.00



DOOSAN LATHE

Doosan

Memo

0.00

22 6

Doosan Lathe

1-Turn as per Folio FA597 Rev: N/A & Dwg D3407 Rev: E U2-Deburr

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

22 6

Quality Control

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

22 11.9.28

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

130

Identify as per dwg & Stock Location: W/ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

EL 11-9-28 (122)

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11-9-28 10
MF 11-09-28

W/O:

WORK ORDER CHANGES

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Picklist Print

Monday, September 26, 2011 10:31:55 AM

Page 1

Work Order ID: 74154



Parent Item: D3407-3



Parent Item Name: Stem

Start Date: 9/26/2011

Required Date: 9/28/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750 		Purchased		No		100	f	24.8240	0.366	11.55789 		SA 11/9/26	

17-4 round bar .750

Location	Loc Qty	Loc Code
MAT030	24.824	
117683	0.465	
118483	0.359	
118641	24	

9.25 ft

Out of material

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	JUL15
Description: Stem	Part Number:	D3407-3
Inspection Dwg: D3407	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

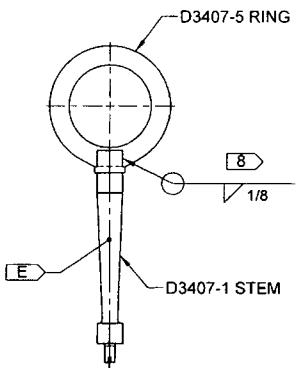
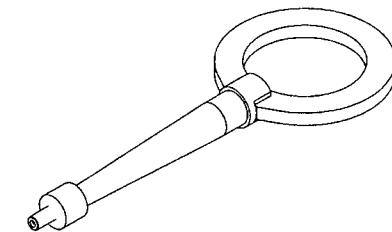
Measured by:	<u>SA</u>	Audited by:	<u>DS</u>	Prototype Approval:	N/A
Date:	15/3/26	Date:	11.9.26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	 

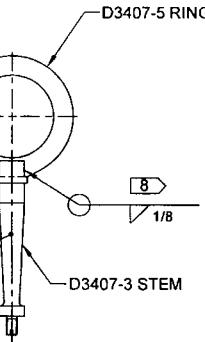
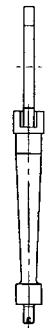
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E

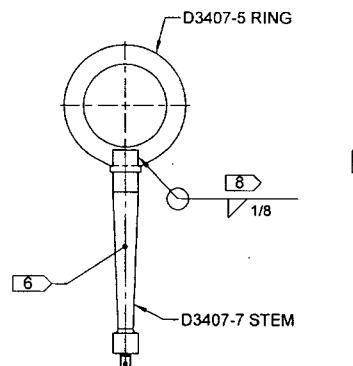
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED
02/08/2014

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

MO 2/15/14

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 5 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1P</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>1P</i>	PORT HADLOCK, WA	
CHECKED	<i>1P</i>	REV. E	
MFG. APPR.	<i>1P</i>	DRAWING NO. D3407 SHEET 1 OF 5	
APPROVED	<i>1P</i>	TITLE	SCALE
DE APPR.	<i>1P</i>	TOW RING NTS	
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8 7 6 5 4 3 2 1

A

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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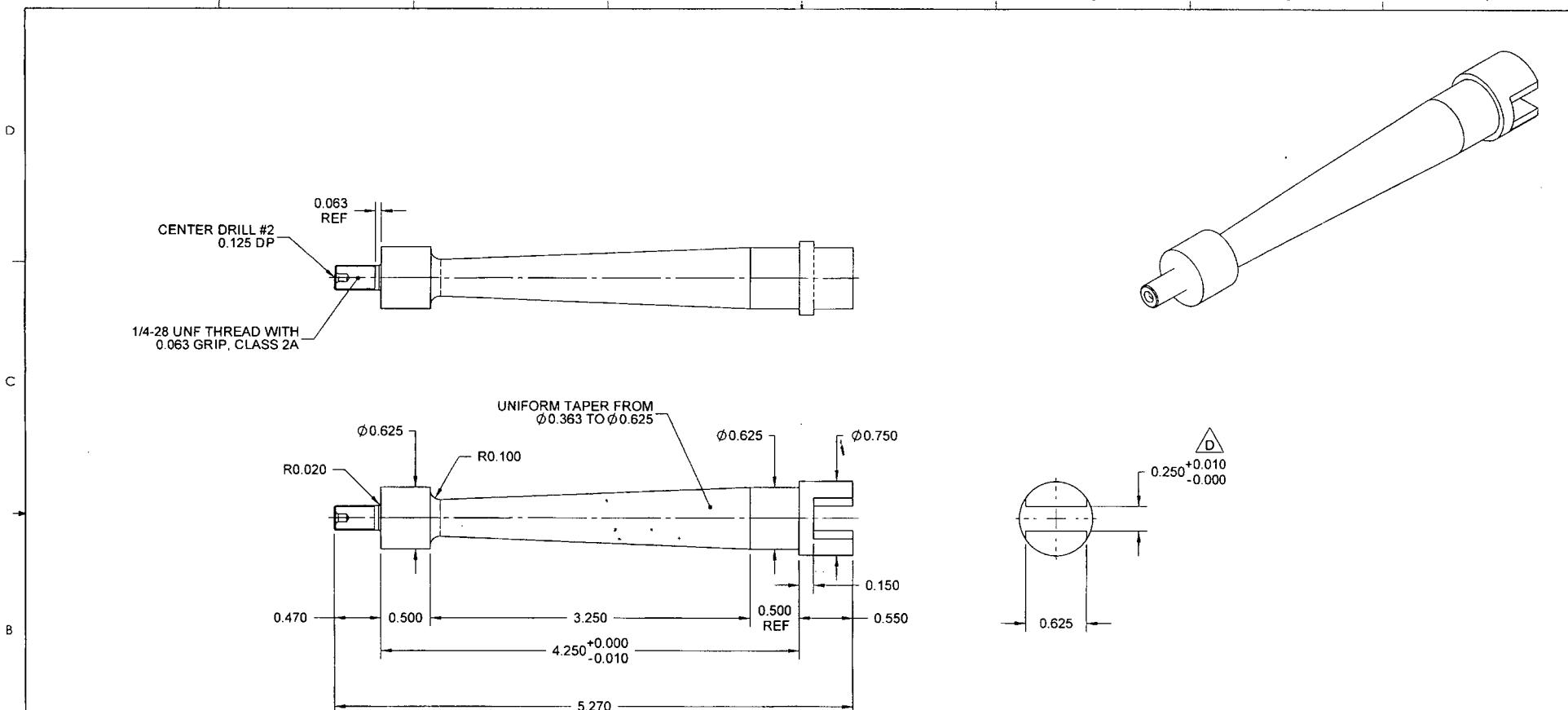
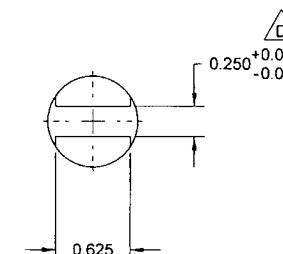
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2

1

D3407-1 STEM

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

RELEASED
[Signature]

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3407	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOW RING	NTS
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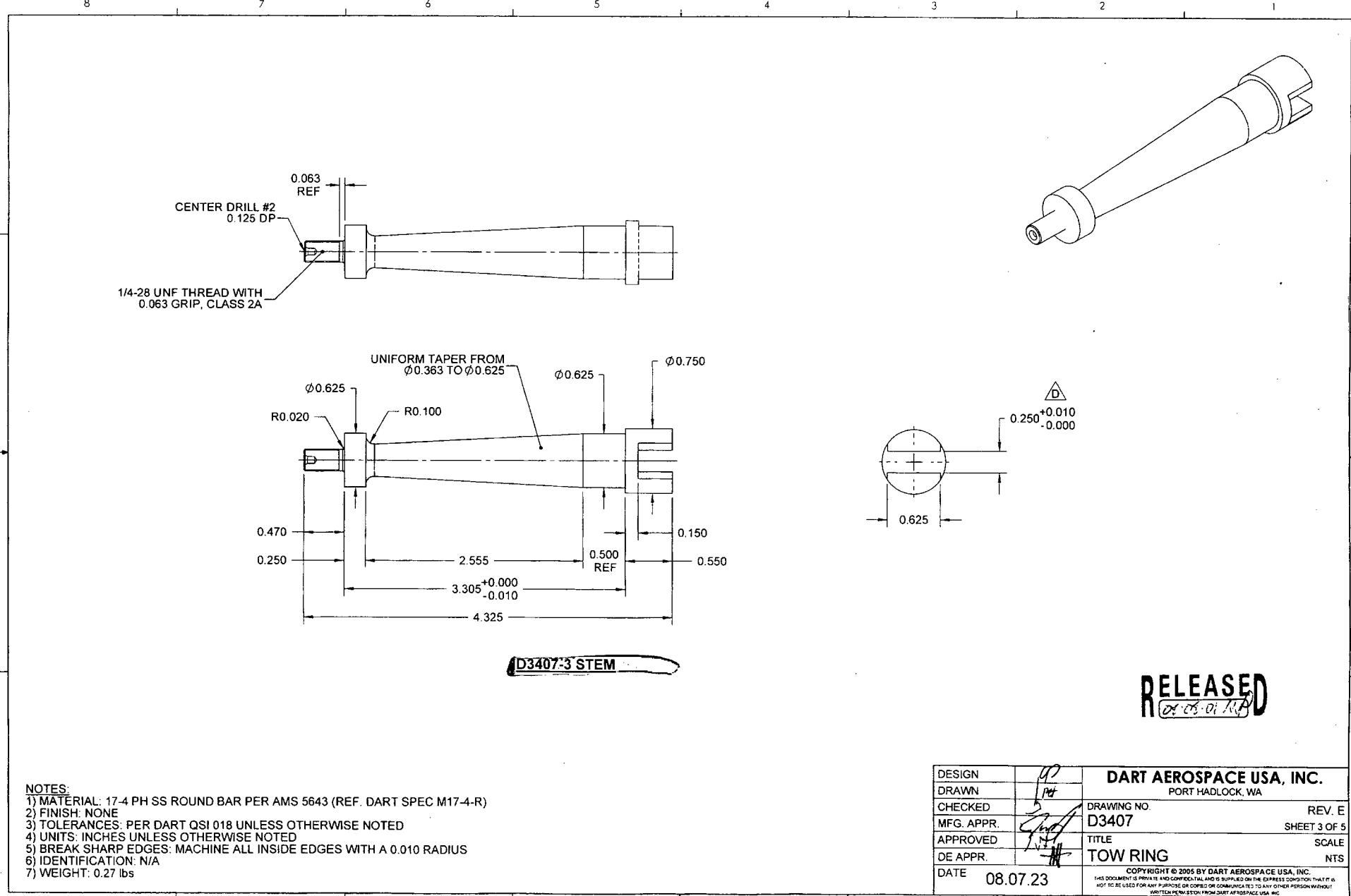
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RELEASED
08-07-23

DESIGN	97	DART AEROSPACE USA, INC.
DRAWN	PT	PORT HADLOCK, WA
CHECKED	5	DRAWING NO. REV. E
MFG. APPR.	<i>[Signature]</i>	D3407 SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE SCALE
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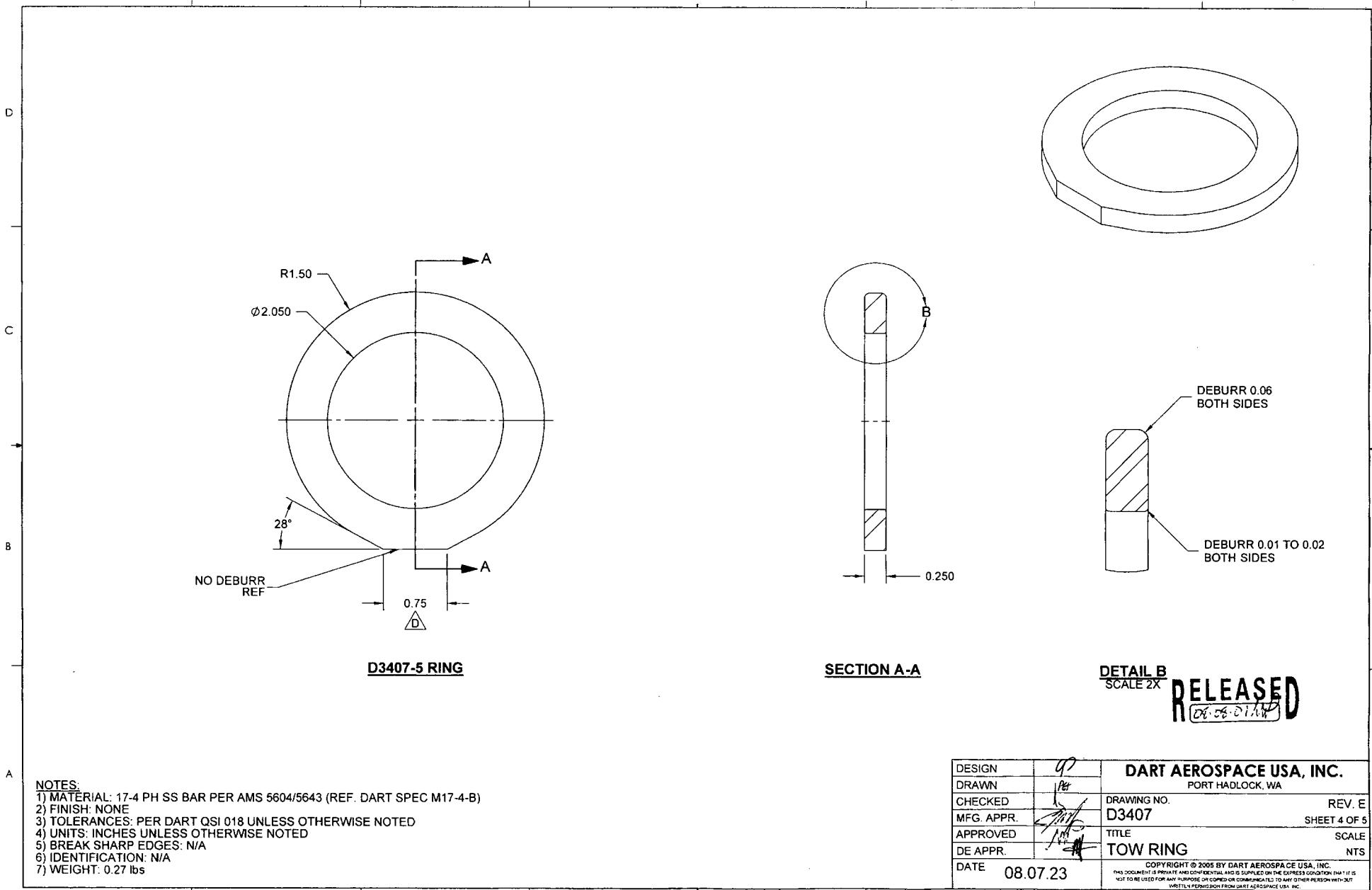
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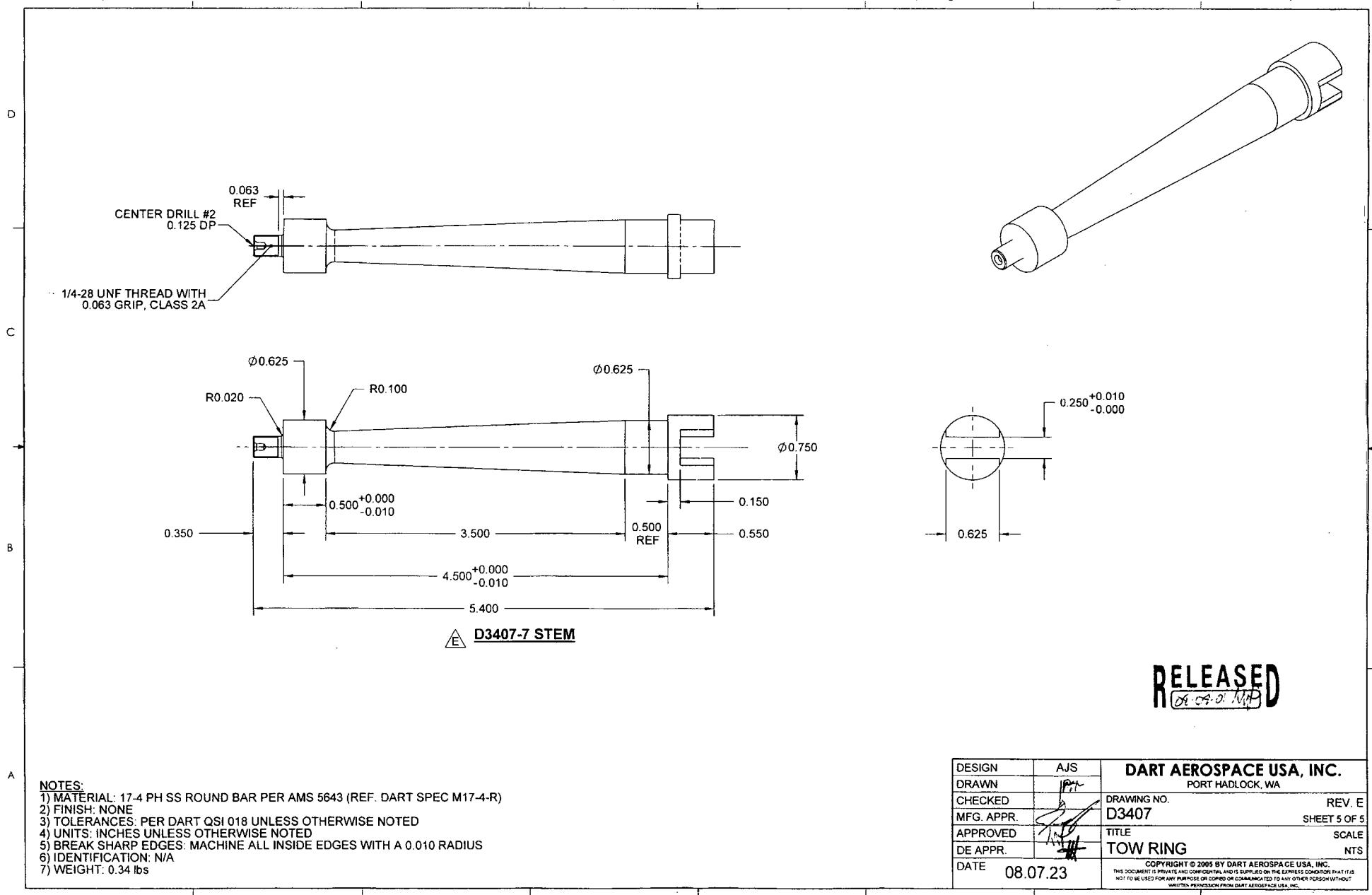
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DESIGN	AJS	DART AEROSPACE USA, INC.
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CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3407 SHEET 5 OF 5
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